### DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

# WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-013319 Address: 333 Burma Road **Date Inspected:** 21-Apr-2010

City: Oakland, CA 94607

**OSM Arrival Time:** 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**CWI Name: CWI Present:** Yes No An Qing Xiang, Tu Jun **Inspected CWI report:** Yes No **Rod Oven in Use:** Yes No N/A N/A Yes N/A N/A **Electrode to specification:** No Weld Procedures Followed: Yes No Yes N/A **Qualified Welders:** No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:** 

34-0006 **Bridge No: Component:** Tower

## **Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Bay 11, Tower Strut Flange Plate

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

ND1-STSA4-6-143M-2-7A/B, 8A/B

ND1-STSA4-6-143M-1-7A/B, 8A/B

ED1-STSA4-6-143M-2-7A/B, 8A/B

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY11

TOWER GRILLAGE PLATE

SAW welding of weld joint 9B located on GTSA5-B/G.

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Welder is identified as 042195. ZPMC QC is identified as Mr. Xu Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

SAW welding of weld joint 10B located on GTSA5-B/G.

Welder is identified as 047304. ZPMC QC is identified as Mr. Xu Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

## EAST TOWER LIFT 4, FIT LUG

FCAW welding of weld joint 111 located on ESTL4-2C/L.

Welder is identified as 040759. ZPMC QC is identified as Mr. Li Lin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2333-Tc-P4-F.

#### WEST TOWER LIFT 5, AB CORNER REPAIR

SMAW welding of weld joint 20A/B(Repair) located on WSD1-TL5-4B/F.

Welder is identified as 040690. ZPMC CWI is identified as Mr. An Qing Xiang.

The welding variables recorded by QC appeared to comply with WPS-485-SMAW-1G(1F)-REPAIR.

#### PADEYE ON TOWER SKIRT PLATE

SMAW welding of weld joint 18 located on WSD1-A804A/B.

Welder is identified as 251194. ZPMC QC is identified as Mr. Xu Jin Long.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112-PADEYE.

#### **BAY 10**

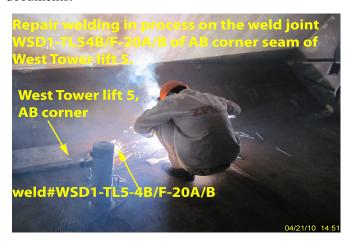
## TOWER FACADE PLATE

SAW welding of weld joint 12 located on SD1-SFSA4-7A/B.

Welder is identified as 052917. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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## **Summary of Conversations:**

Only general conversation was held between QA and QC concerning this project.

## **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest: 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer